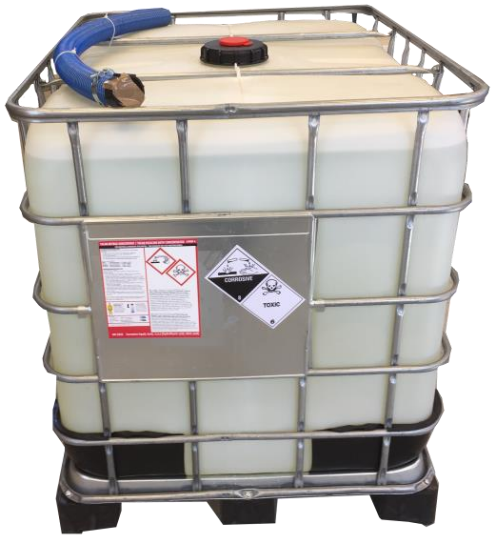
TACAB Pickling bath standard (concentrated)



DESCRIPTION

Pickling bath is used for simultaneous pickling of welding joints and free surfaces for larger welded stainless-steel constructions. After pickling and ample rinsing with high pressure fresh water with low the corrosive resistance is restored in the welded area.

PHYSICAL AND CHEMICAL PROPERTIES

Appearance:	colorless liquid
Odor:	Pungent
PH Value:	<1,5 (10 g/l)
Solubility:	Fully soluble and miscible
Concentration:	Nitric acid: 35-40%
	Hydrofluoric acid: 8-11%

CHARACTERISTICS

Liquid. Concentrate to be mixed with water to the desired strength.
Effectively removes welding oxides, discolorations and surface rust.

ADVANTAGES

- Restores the Stainless steel's original resistance to corrosion.
- Gives a bright surface clean from oxides and discolorations.
- Efficient and economical.

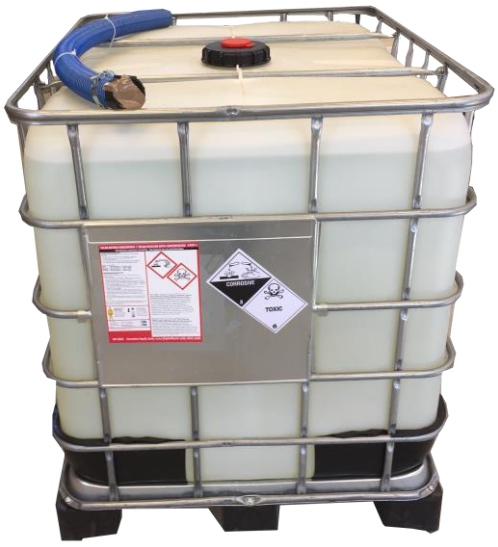
AREAS OF USE

Use to remove stains and rust.
Use to remove welding oxides.
Use to restore the passivity layer (restores the material's original stainless properties).

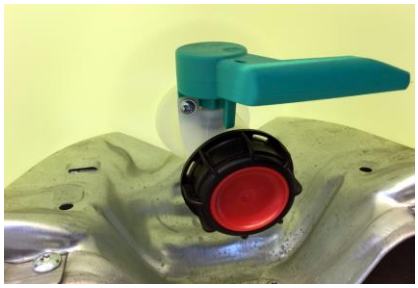
DIRECTION FOR USE

1. TACAB Standard Concentrated pickling batch shall be mixed:
   Stainless steels and acid resistance steels: 1-part concentrated bath + 2 parts of water.
   Duplex: 1-part concentrated bath + 1-part water.
   Super Duplex: 0.5 parts of concentrated bath + 1-part water.
2. Remove as much slag, oxide and weld defects as possible. We recommend a stainless-steel wire brush. It is considerably easier when the weld is still warm, and the welding oxide is not so hard. If necessary, wash off dirt, oil, grease and paint which could impede the pickling process.
3. Let the weld cool to room temperature (or not more than 40°C).
4. The pickling bath need to maintain a temperature of >=20°C to avoid prolonged pickling times.
5. Lower the structure/components into the pickling bath with a traversing crane or similar device. Then wait until the pickling process has been completed. Let the pickling liquid run off into the bath when components are taken out. This minimises spillage. Please be careful to prevent the pickling solution from drying before components are flushed clean.
   Customize pickling time according to your requirements (temperature of the bath and fitness as well as materials and welding method).
6. Flush carefully with a high-pressure washer. Use drinking water quality with low chloride content, preferably below 50 ppm. It is very important that no residues remain after treatment. Remaining acid residues can give rise to corrosion.
7. Leave the pickled detail to air dry in a protected environment for at least 3 hours.
   Preferably overnight (to allow the passivated layer to be re-formed.

DIRECTION FOR FILLING/MIXING



1. Choose mixing ratio:
   Stainless steels and acid resistance steels: 1-part concentrated bath + 2 parts of water.
   Duplex: 1-part concentrated bath + 1-part water.
   Super Duplex: 0.5 parts of concentrated bath + 1-part water.
2. Make sure the bath can handle the volume you are about to mix.
   There should be at least 15 cm left between the surface and the edge of the pickling tank when the bath is mixed.
3. Add water. Always use good quality drinking water.
   The chloride content should < 50 ppm.
4. Take on personal protective equipment.
5. Remove the cap on the drain valve. If there is a protective foil inside the lid, remove it.
6. Connect the supplied drain hose to the valve.
7. Unscrew the transport securing screw located just below the handle of the valve.
8. Lift up the IBC container above the edge of the pickling tank making sure that the drain hose points into the pickling tank.
9. Now open the lid on top of the IBC container.
   It is important that this is done before the valve is opened, otherwise the container can be folded and damaged by the negative pressure that occurs.
10. Open the drain valve to 30%.
11. Check that everything is ok.
12. If desired, open the drain valve to 100%.
13. *Take care to rinse the IBC container internally with water hose or water jet (approx. 10 liters). Let this water drain into the pickling tank. IBC container is now cleaned.*
14. *Close the drain valve*
15. *Remove the drain hose.*
16. *Repeat 5-15 if several IBC containers are to be emptied.*
17. *Clean the drain hose internally and externally with plenty of water.*



PACKAGE SIZES

Can - 25 kg, Barrel - 200 kg, IBC - 1000 L

DURABILITY

The shelf life of unopened TACAB pickling products is 3 years. 1 year for opened packaging.

SAFETY PRECAUTIONS

PERSONAL SAFETY

Full protective mask must be used as the product is classified as toxic. The protective mask must be fitted with a type B (gray) respiratory filter and a P2 particle filter. Pickling products can cause severe burns on skin contact. This is avoided by using acid-proof overalls, gloves and boots. For more information see the product's safety data sheet.
Hexafluorine (first aid product) should be present in the workplace.

STORAGE

TACAB pickling products should be stored indoors at room temperature. They should be kept standing and closed.
Storage should be done in a limited area and inaccessible to unauthorized persons.

WASTE DISPOSAL

Waste and residues of this product (including neutralized residues when containing heavy metals) and contaminated packaging must be taken care of as hazardous waste.
Remains must not be released into sewers or watercourses or into the environment (for more information see the product's safety data sheet). Consult local authorities for information on waste management.

OTHERS

Always strive for distance between the parts (details that are in contact with each other can discoloration and cause the life of the bath to be shortened. It is advantageous during the pickling process to have a slight stirring in the bath. Use pump or propeller. Propellers are the best option. The circulation gives better pickling results and shorter pickling times.
The bath can advantageously be provided with an openable cover (the cover must be closed when pickling does not take place). This effectively prevents evaporation and reduces the need for maintenance